

Work Order ID 67627

Monday, March 28, 2011 3:15:56 PM



Page 1

Item ID: D4037-3

Accept



Setup Start



Revision ID:

Item Name: Fwd Crossbeam

Stop



Start Date: 3/28/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: NF

Date: 11-03-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4037

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4037-3 BLANK

11-3-24

②

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA878 AND DWG

FOLIO REV: GA

DWG REV: C

DEBURR

11/03/30

2

Ø

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67627

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Page 2

Item ID:	D4037-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Fwd Crossbeam				Stop	
Start Date:	3/28/2011	Start Qty:	1.00			
Required Date:	4/4/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		11/03/31		2	4		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11/04/01		2	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12	0		11/04

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Page 3

Item ID: D4037-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Crossbeam

Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

M115951

0.00

2 BL 11-4-11

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2 φ M 1104/06

170



Packaging

Packaging

Identify as per dwg & Stock Location: ste

0.00

Memo

0.00

Call 4/5 R

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

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Monday, March 28, 2011 3:15:56 PM



Page 4

Item ID: D4037-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Crossbeam

Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/05

U 1104-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 3:15:52 PM

Page 1

Work Order ID: 67627

Parent Item: D4037-3

Parent Item Name: Fwd Crossbeam



Start Date: 3/28/2011

Required Date: 4/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC
REV:B AS PER REV B 10-04-19 JLM VERIFIED BY:EC
C:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD
IPP
IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased	No			100	f	31.5000	3.9	4.105263			



B11-3-24

Location	Loc Qty	Loc Code
MAT005	31.5	
114899	12	
115093	4.5	
115173	12	
9544	3	

114899
115093

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

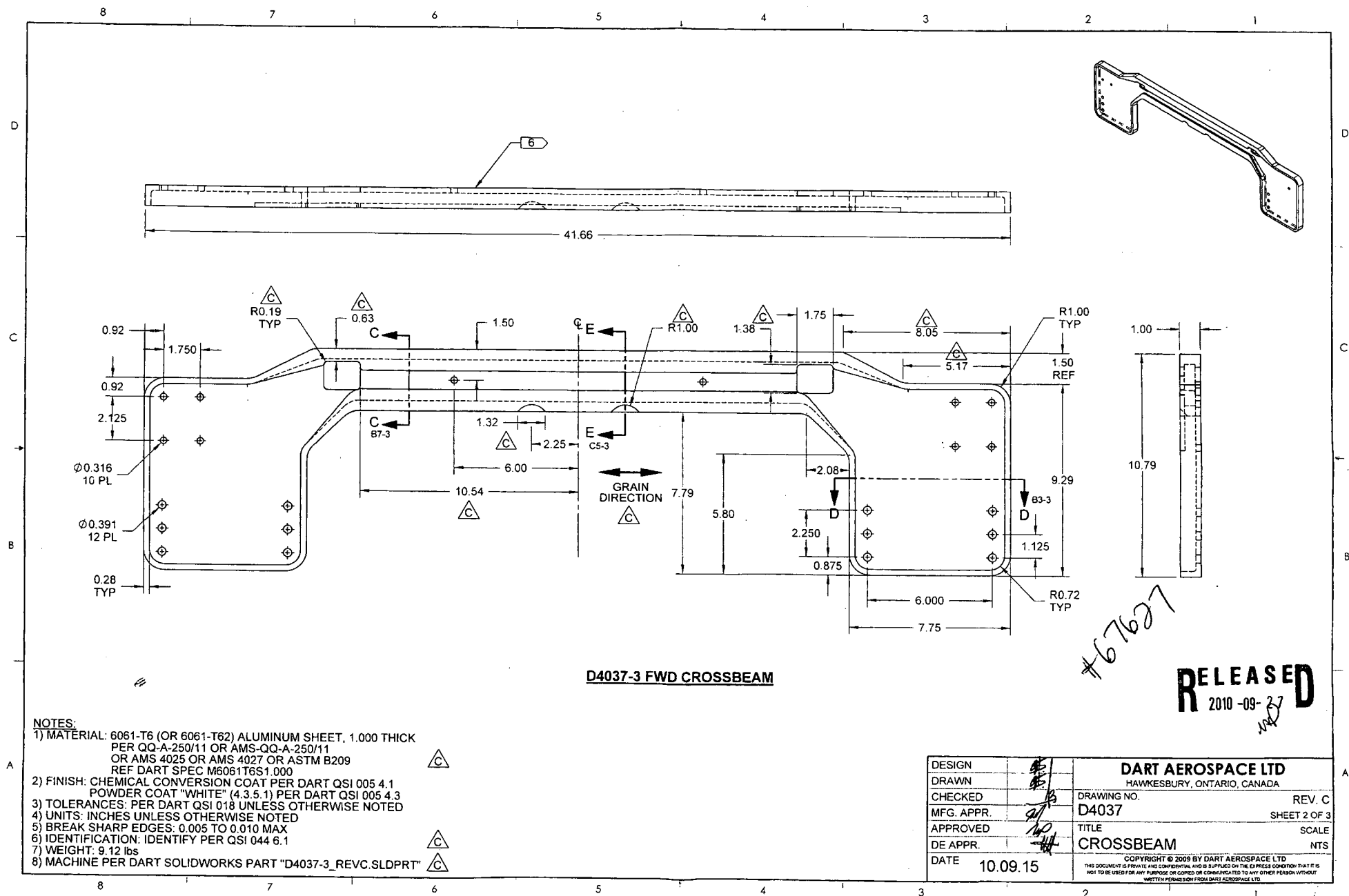
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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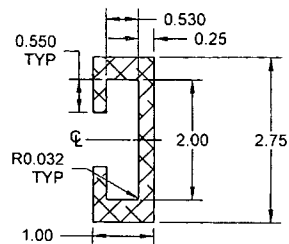
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

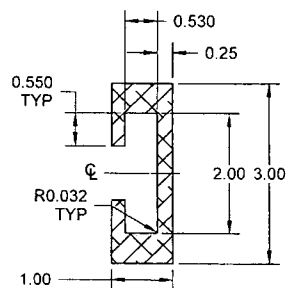
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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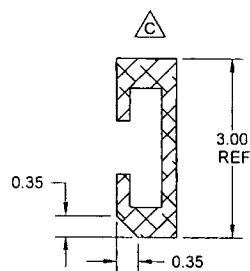
NOTE: Date & initial all entries



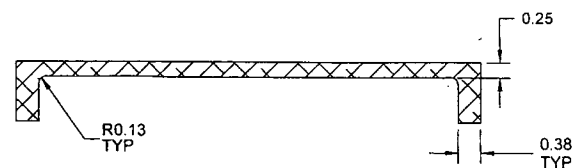
SECTION A-A B6-1
SCALE 2X



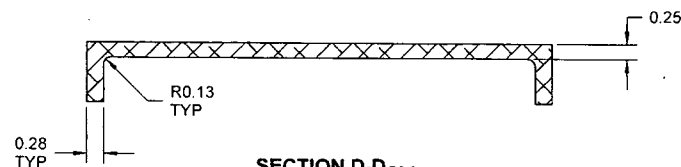
SECTION C-C B6-2
SCALE 2X



SECTION E-E C5-2
SCALE 2X



SECTION B-B B2-1
SCALE 2X



SECTION D-D B3-2
SCALE 2X

#67627

RELEASED
2010-09-27

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4037	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE CROSSBEAM	SCALE
DE APPR.			NTS
DATE	10.09.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 67627
Description: Fwd Crossbeam		Part Number: D4037-3
Inspection Dwg: D4037	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
41.66	+/-0.030	41.660	✓		TAPE	GA-12
0.92	+/-0.030	0.918	✓		Vern	GA-01
1.75	+/-0.030	1.750	✓		"	"
0.92	+/-0.030	0.919	✓		"	"
2.125	+/-0.010	2.125	✓		"	"
Ø0.316	+0.006/-0.001	Ø0.317	✓		"	"
Ø0.391	+0.006/-0.001	Ø0.392	✓		"	"
0.28	+/-0.030	0.283	✓		"	"
1.32	+/-0.030	1.320	✓		"	"
7.79	+/-0.030	7.790	✓		H-6	31006
5.80	+/-0.030	5.800	✓		Vern	GA-01
2.250	+/-0.010	2.250	✓		"	"
0.875	+/-0.010	0.876	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
7.75	+/-0.030	7.750	✓		Vern	CNC-02
1.125	+/-0.010	1.125	✓		"	"
9.29	+/-0.030	9.291	✓		"	"
1.75	+/-0.030	1.750	✓		Vern	GA-01
1.38	+/-0.030	1.375	✓		"	"
1.50	+/-0.030	1.500	✓		"	"
0.63	+/-0.030	0.626	✓		"	"
1.00	+/-0.030	0.996	✓			
10.79	+/-0.030	10.791	✓		H-6	31006
3.00	+/-0.030	3.001	✓		Vern	GA-01
2.00	+/-0.030	2.003	✓		"	"
0.25	+/-0.030	0.256	✓		"	"
0.530	+/-0.010	0.524	✓		"	"
0.35	+/-0.030	0.345	✓		"	"
0.35	+/-0.030	0.345	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-6	ref.

Measured by: B.A.	Audited by: [Signature]	Preliminary Approval:
Date: 11/03/31	Date: 11/04/01	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	10.10.07	Dimensions updated per Dwg Rev C	KJ	[Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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